

Date: Monday, 6/26/2006 3:46:50 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET (A119) STRUT
Job Number	: 27694		
Estimate Number	: 12436		
P.O. Number	: N/A	Part Number	: D35171
This Issue	: 6/26/2006 S.O. No. : N/A	Drawing Number	: D3517 PRELIMINARY
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : R & D SM/MED FAB	Drawing Revision	: A PRELIMINARY
Previous Run	: N/A	Material	: N/A
Written By	: <u>SKR</u> COMMENT BEH	Due Date	: 7/3/2006 Qty: 2 Um: Each
Checked & Approved By	: <u>KG 06.06.26</u>		
Comment	: EST rev. A 05.06.06 preliminary EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X04000	6061-T6 Bar .75" x 4.0"
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Comment: Qty.: 0.6999 f(s)/Unit Total: 1.3999 f(s)
 6061-T6 Bar .75" x 4.0"
 Batch: M4547

SAP 06.07.17

②

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3517
 Dwg Rev: A
 Prog Rev: A

2-Open holes to finish size as per Dwg D3517

3-Deburr if necessary

SAP 06.07.17

②

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

KG 06.07.17

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

KG 06.07.17

②

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/07/24

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/26/2006 3:46:50 PM
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Process Sheet

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Drawing Name: BASKET (A119) STRUT

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Part Number: D35171

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: —

AD

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.18

Job Completion



06.07.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr				

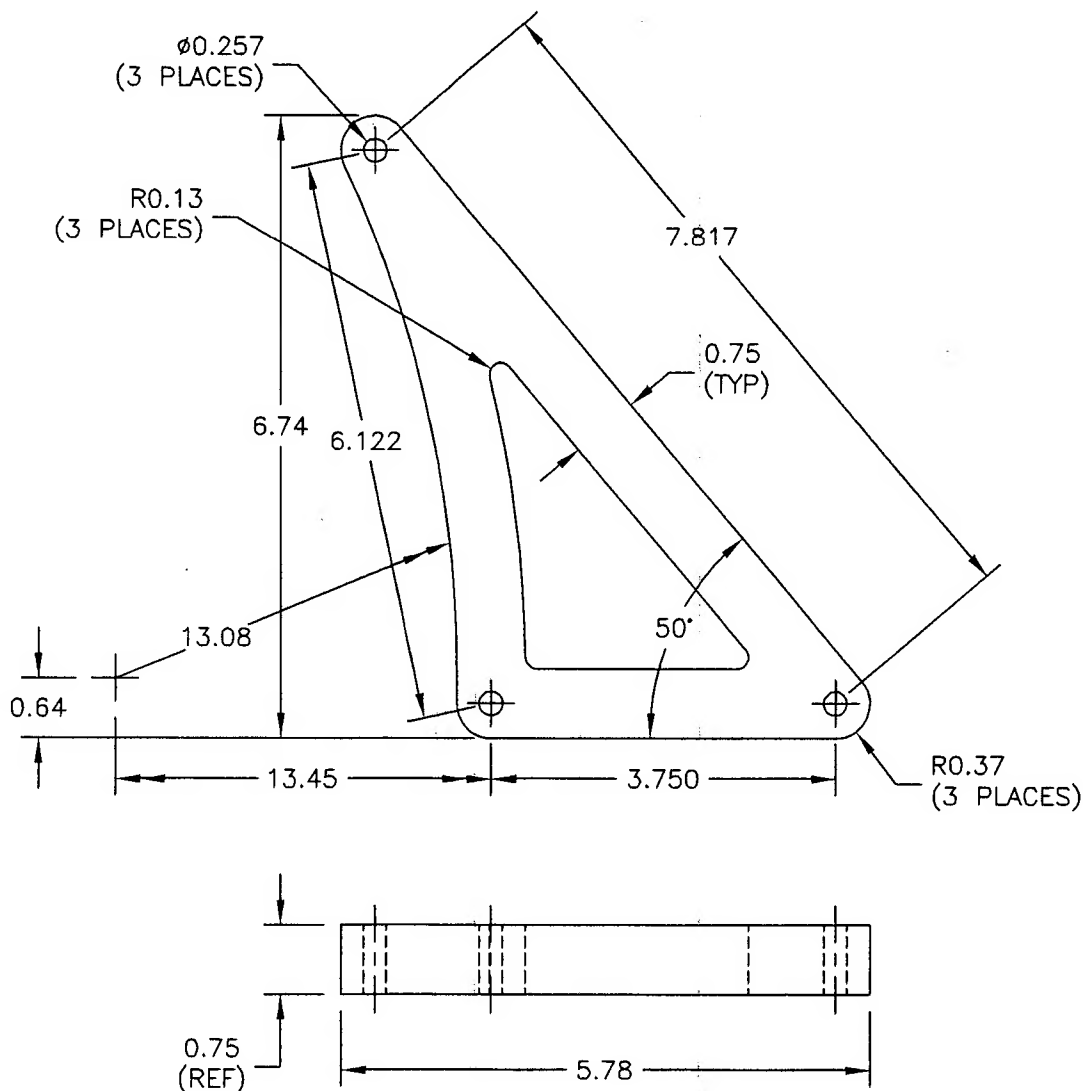
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3517	REV. A SHEET 1 OF 1
DATE 06.06.07		TITLE BASKET (A119) STRUT	SCALE 1:2
A	06.06.07	NEW ISSUE	



D3517-1 STRUT

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T6512/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART MATERIAL SPEC M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) IDENTIFY WITH DART P/N D3517-1 USING FINE POINT PERMANENT INK MARKER
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27694

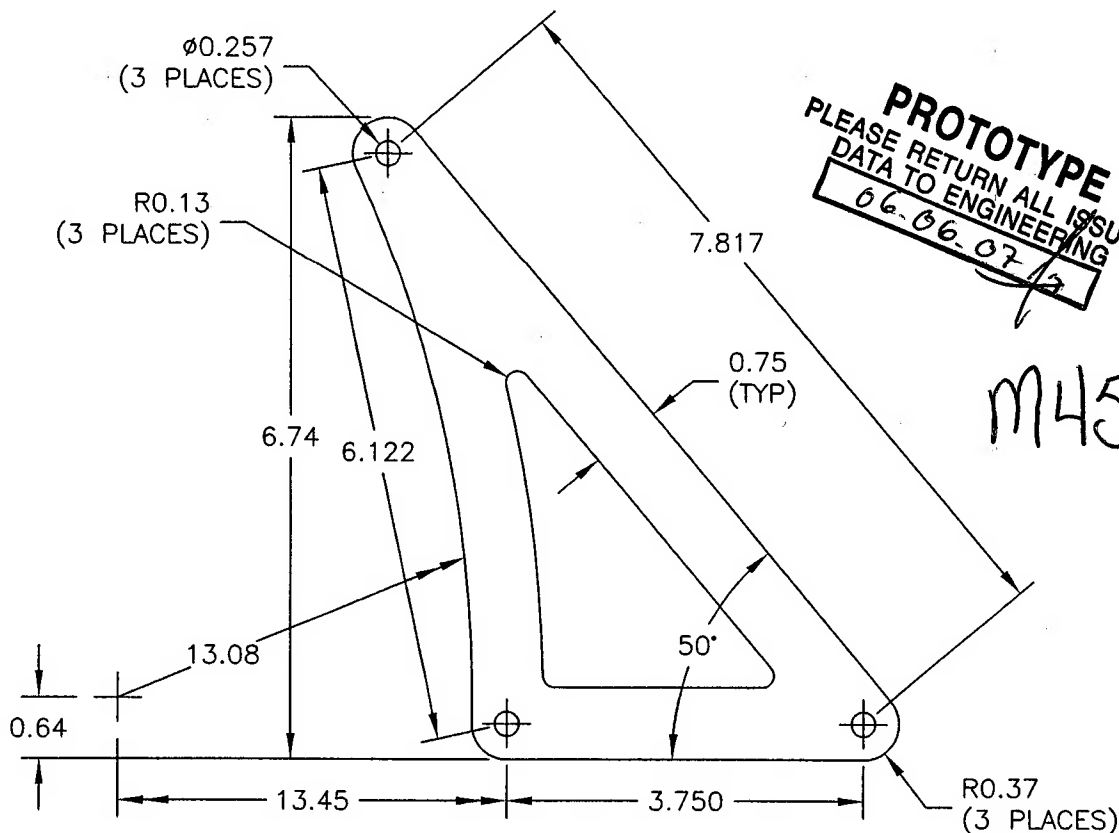
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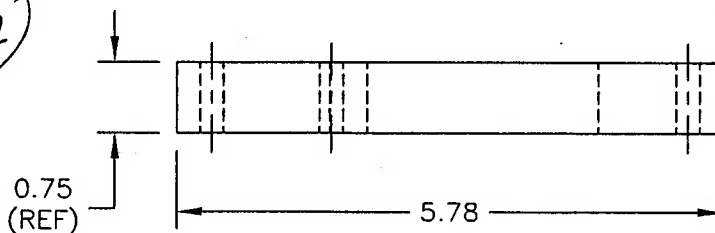
PRELIMINARY ISSUE

06.06.07

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3517	REV. A SHEET 1 OF 1
DATE 06.06.07		TITLE BASKET (A119) STRUT	SCALE 1:2
A	06.06.07	NEW ISSUE	



PLS, MAKE 2



Done

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